



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PRELIMINARY ISSUE

D5565-1

Job Sheet 176948

Accounting Job RD17-1054-01



Part No: D5565-1

Job Qty: 1 ea

Part Name: Wearplate



Part Weight: 0 lbs

Job Created: 5/3/18

Due Date: 5/11/18

Type: R+D

Status: Scheduled

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Note: D5565 REV.A-~~prelim~~ IPP REV:A 17.11.27 NEW ISSUE DD VERF:JFS IPP REV:B 18.05.02 AS PER DWG
REV.A-PRELIM DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Waterjet2		SC 18/05/08
110	Waterjet	1 pcs	5/11/18	5/11/18	0.00	0.10	Waterjet1		SC 18/05/08
120	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC2		SC 18/05/08
130	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC8		38
140	Brake NC	1 pcs	5/11/18	5/11/18	0.00	0.10	Brake NC 1		9-89
150	QC	1 pcs	5/11/18	5/11/18	0.00	0.00	QC5		30 18-05-18
160	Packaging	1 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3		MAY 18 2018
170	QC21-SA	1 Ea	5/11/18	5/11/18	0.00	0.00	QC21		21 MAY 24 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 160 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.7500 sf (.75 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	1	129	0

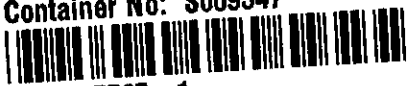
Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Newkesbury, ON K84 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S069547



Part: D5565-1

Job No: 176948

Serial No/Batch: S069547

Revision: A

Inspector:

Date: 06/08/18

DQA: _____ Date: _____

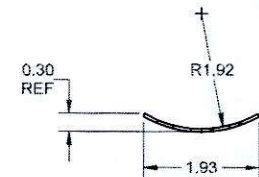
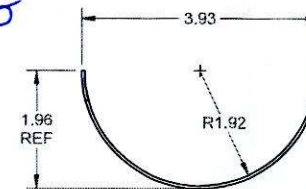
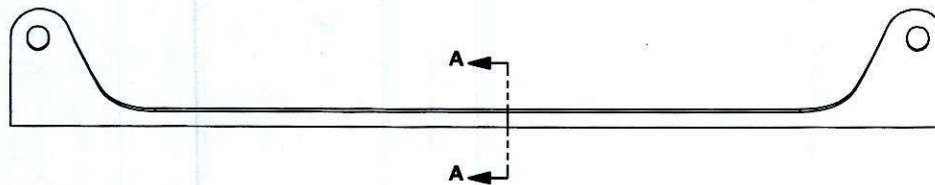
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 176948 MWS
18-05-03



SECTION A-A

D5565-1 WEARPLATE

PRELIMINARY ISSUE

- NOTES:**
1) MATERIAL: MAKE FROM D5565-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.61 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5565	SHEET 3 OF 7
APPROVED	DSW	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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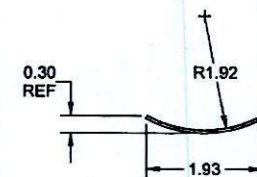
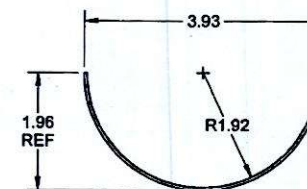
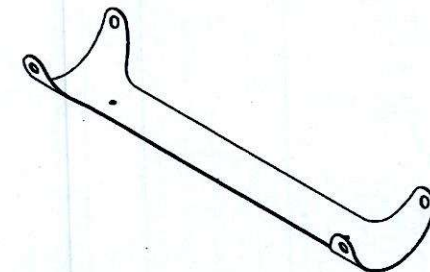
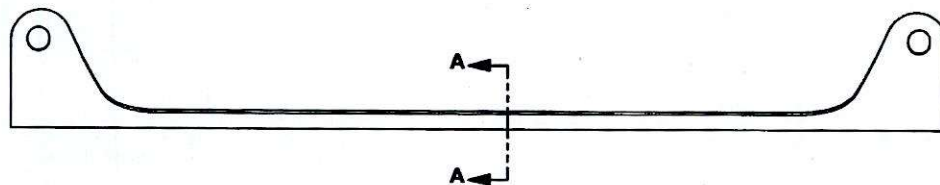
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



SECTION A-A

D5565-1 WEARPLATE

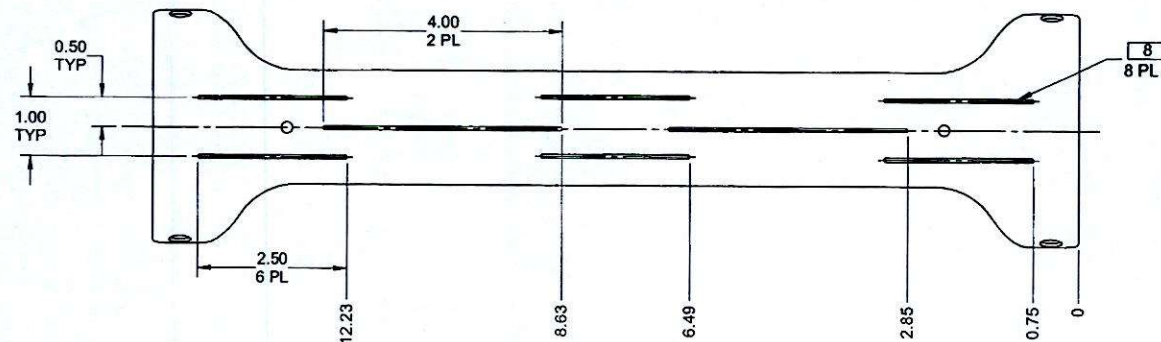
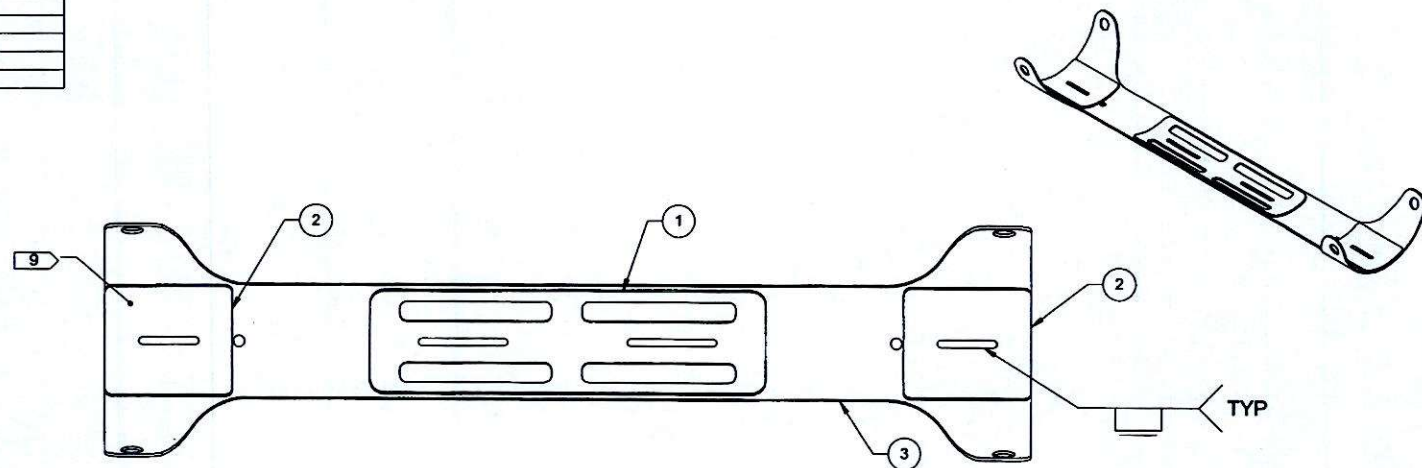
RELEASED
2018 MAY 03

- NOTES:**
- 1) MATERIAL: MAKE FROM D5565-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.61 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5565	SHEET 3 OF 7
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ITEM	QTY	P/N	DESCRIPTION
	X	D5565-041	WEARPLATE ASSY
1	1	D5564-3	MIDDLE SPACER
2	2	D5564-5	SPACER
3	1	D5565-1	WEARPLATE



D5565-041 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.90 lbs
- 8) BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATIC WELDING) OR BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02 - 0.04 THICK PER DART QSI 005 4.9

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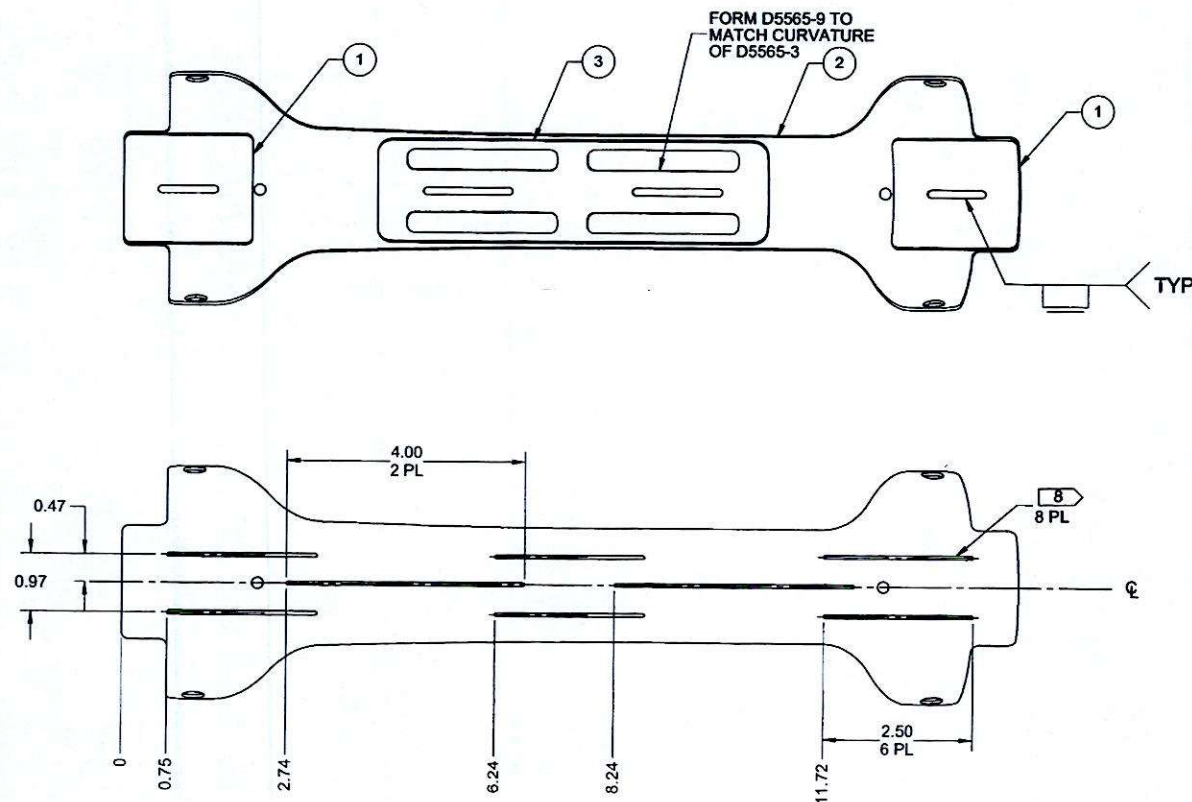
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REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	DD		
APPROVED	DSW		
DE APPR.	DS		
DATE	17.10.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5565** REV. A
TITLE **WEARPLATE** SCALE NTS

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ITEM	QTY	P/N	DESCRIPTION
	X	D5565-043	WEARPLATE ASSY
1	2	D5564-5	SPACER
2	1	D5565-3	WEARPLATE
3	1	D5565-9	MIDDLE SPACER



D5565-043 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.90 lbs
- 8) BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATIC WELDING) OR
- 9) BUILD UP HARD SURFACING 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02 - 0.04 THICK PER DART QSI 005 4.9

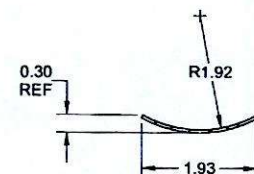
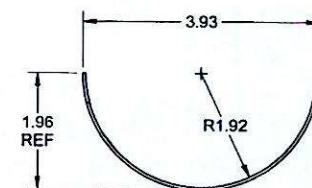
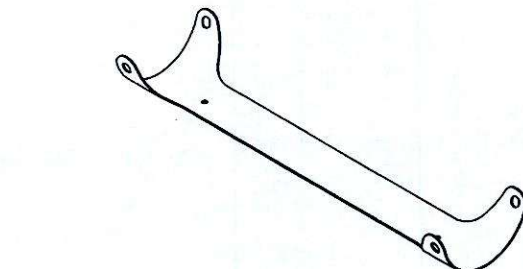
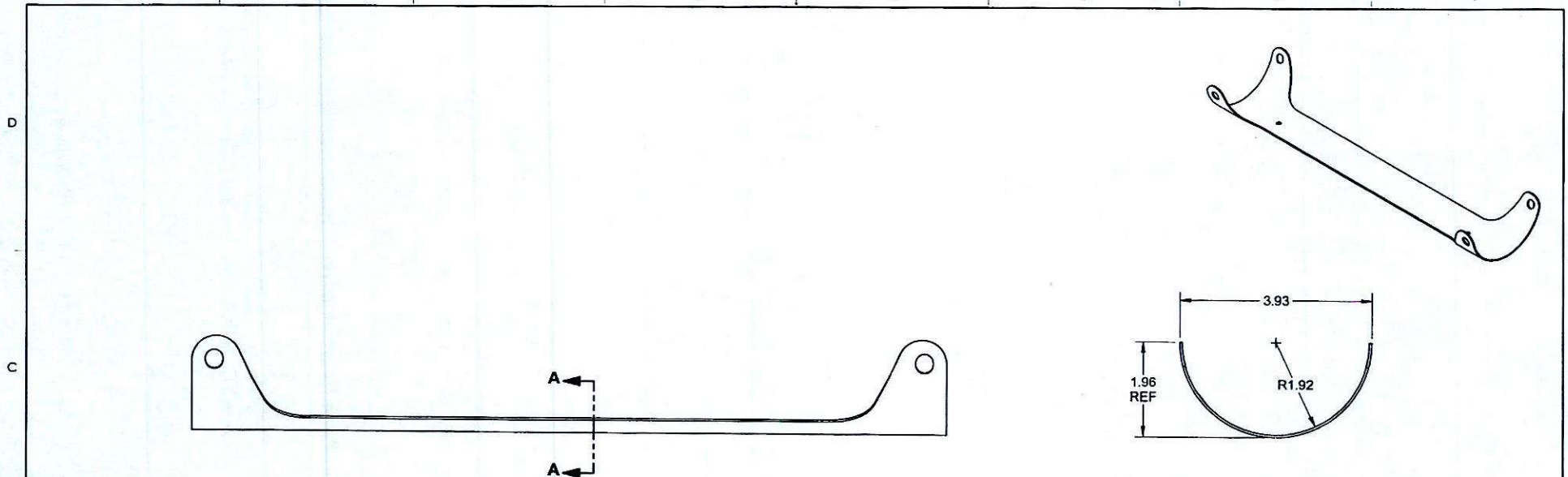
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2018 MAY 03

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MFG. APPR.	DD	D5565	SHEET 2 OF 7
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8 7 6 5 4 3 2 1



SECTION A-A

D5565-1 WEARPLATE

NOTES:

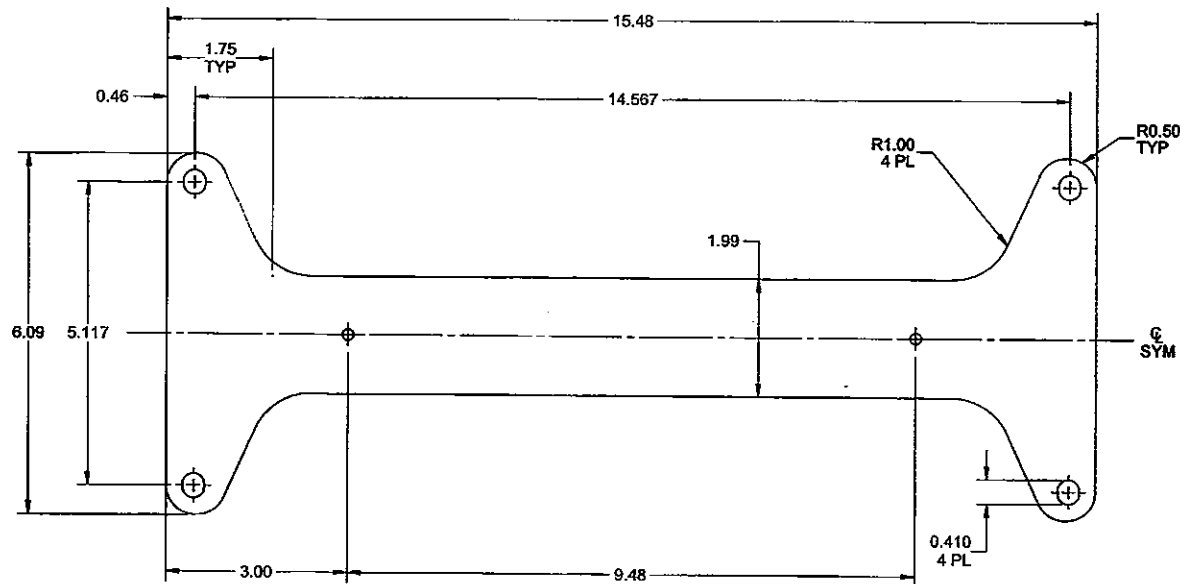
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.61 lbs

RELEASED
2018 MAY 03 *up*

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8 7 6 5 4 3 2 1



D5565-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 18 GAUGE (0.050 THK)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.61 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY D5565-1F.DXF REV. A

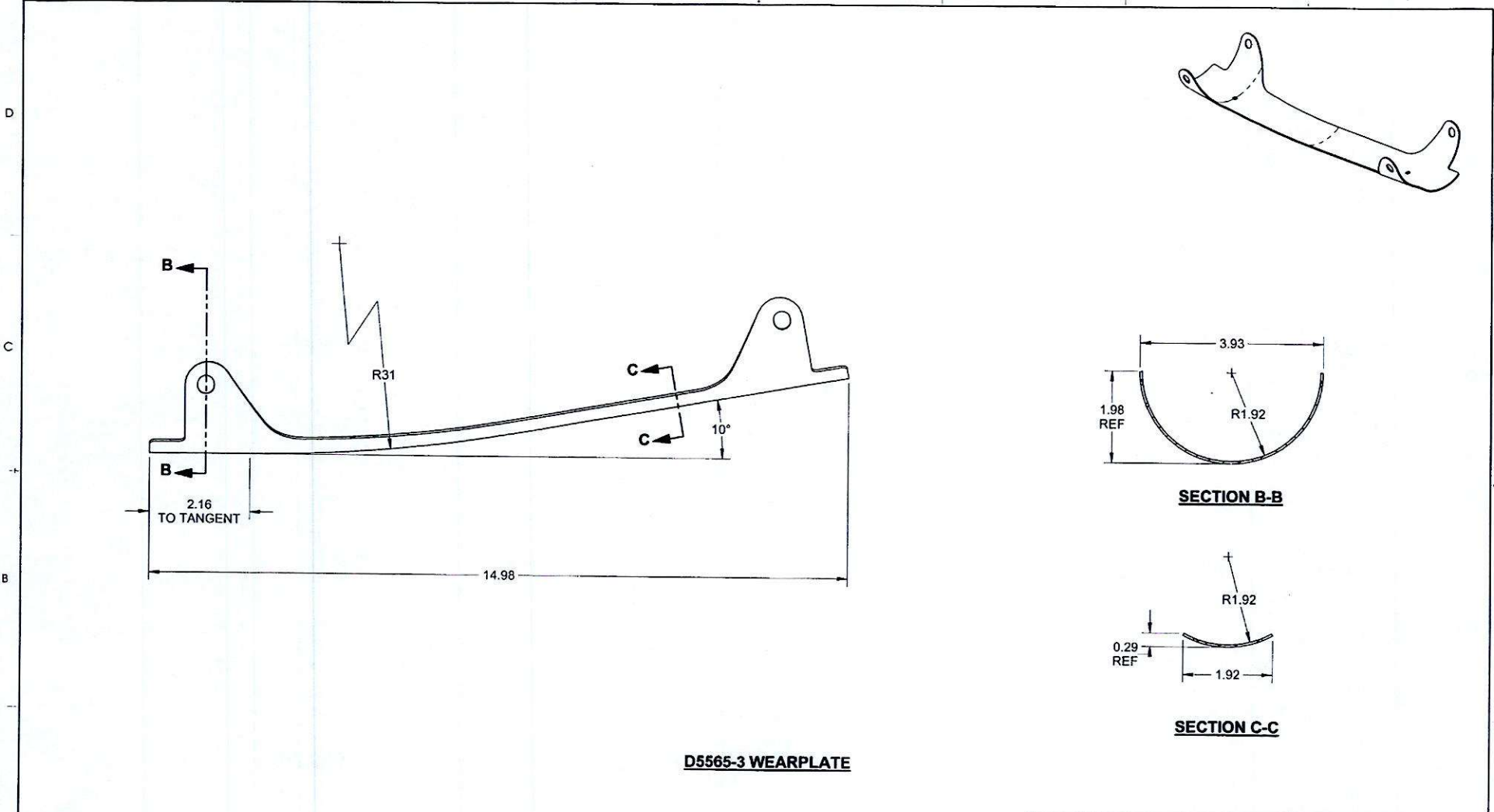
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2018 MAY 03 *gr*

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8 7 6 5 4 3 2 1



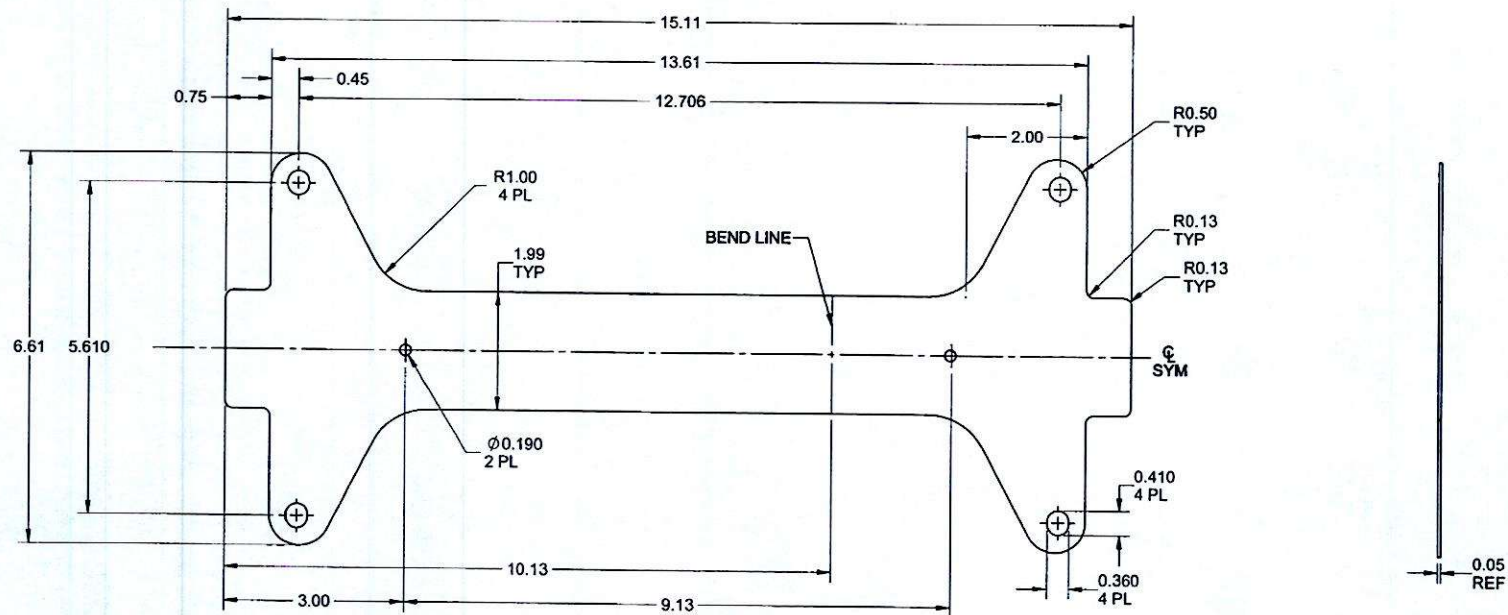
- NOTES:
- 1) MATERIAL: MAKE FROM D5565-3F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs

D5565-3 WEARPLATE

RELEASED
2018 MAY 03

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5565	SHEET 5 OF 7
	APPROVED	DSW	TITLE	SCALE
	DE APPR.	DS	WEARPLATE	NTS
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8 7 6 5 4 3 2 1



D5565-3F FLAT PATTERN

NOTES:

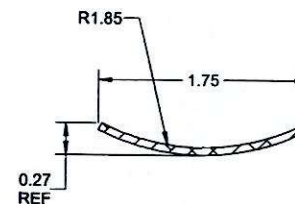
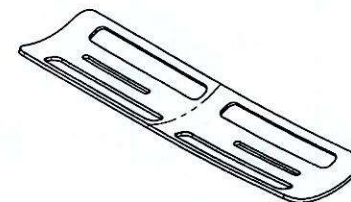
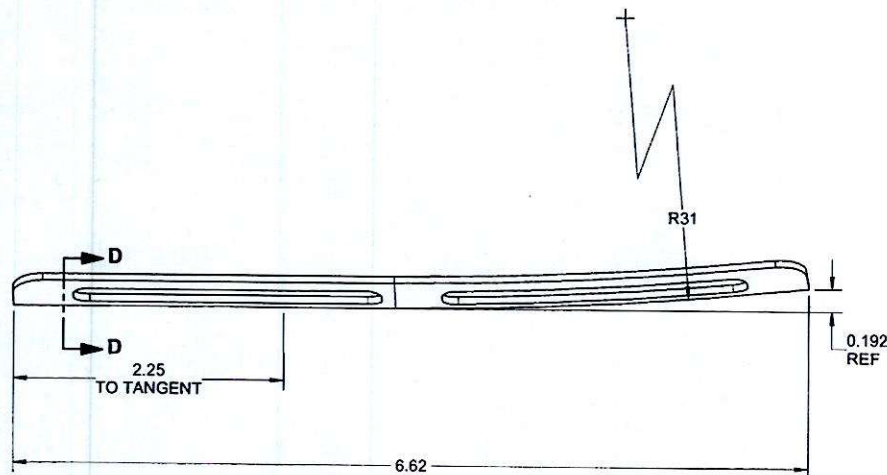
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 18 GAUGE (0.050 THK)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs
- 8) ALL NON DIMENSIONED FEATURES CONTROLLED BY D5565-3F.DXF REV. A

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2018 MAY 03

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DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	DD	D5565	SHEET 6 OF 7
APPROVED	DSW	TITLE	SCALE
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SECTION D-D

D5565-9 MIDDLE SPACER

NOTES:

- 1) MATERIAL: MAKE FROM D5564-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

RELEASED

2018 MAY 03 *g*

APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	DD
APPROVED	DSW
DE APPR.	DS- <i>h</i>
DATE	17.10.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5565

REV. A
SHEET 7 OF 7
SCALE
NTS

TITLE
WEARPLATE

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